

■ Recommended soldering conditions

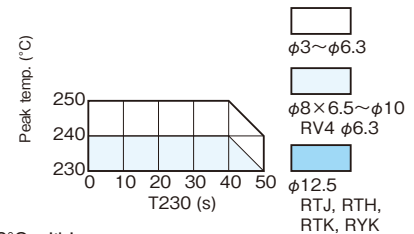
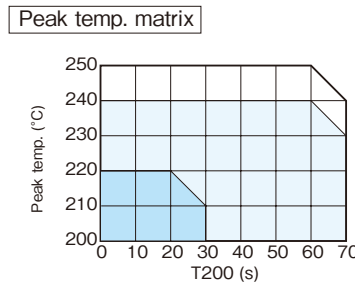
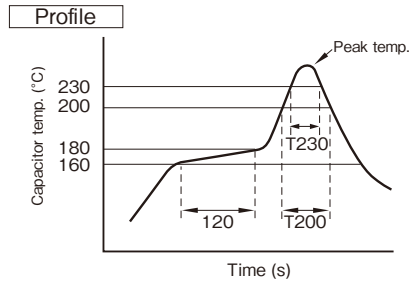
● Chip type aluminum electrolytic capacitors (Lead free)

(1) Methods
See the following

Methods	Reflow soldering	Soldering iron	Flow soldering
Advisability	○	○	×

(2) Soldering iron conditions
Iron tip temperature shall be 400°C±5°C within the duration of 3^{±1}seconds.

(3) Reflow soldering conditions



T200 : Duration while capacitor head temperature exceeds 200°C (s)

T230 : Duration while capacitor head temperature exceeds 230°C (s)

The measurement temperature point is the case top.

1. Preheating shall be under 180°C within 120 seconds.
2. Peak temperature shall be within the peak temperature matrix.
3. For conditions exceeding the tolerances, consult with us.

● Aluminum electrolytic capacitors (Lead free)

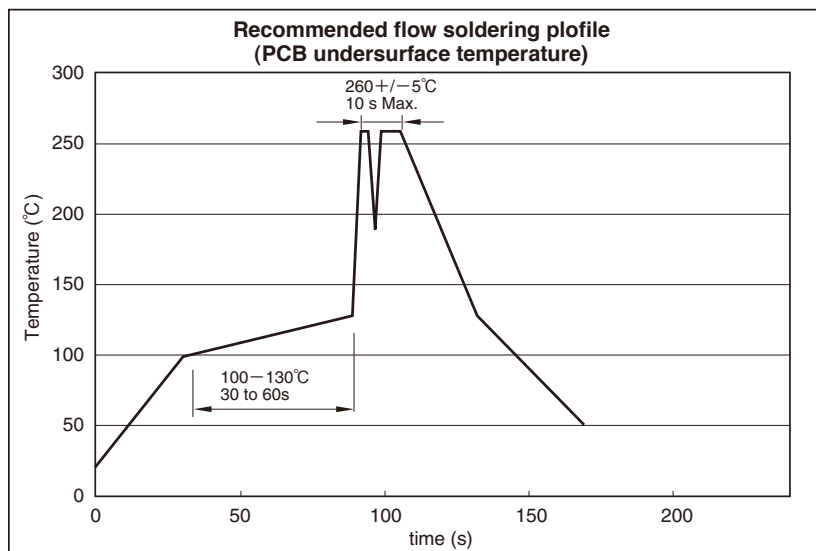
(1) Methods
See the following

Methods	Reflow soldering	Soldering iron	Flow soldering
Advisability	×	○	○

(2) Soldering iron conditions
Iron tip temperature shall be 400°C±5°C within the duration of 3^{±1}seconds.

(3) Flow soldering conditions

The recommendation soldering conditions of the product in which flow soldering is possible are as graph.



Caution for Using aluminum Electrolytic Capacitors

- (1) Do not dip the capacitor into melted solder.
- (2) Do not flux other part than the terminals.
- (3) If there is a direct contact between the sleeve of the capacitor and the printed circuit pattern or a metal part of another component such as a lead wire, it may cause shrinkage of crack.
- (4) If the application is for extended use, understand and manage the soldering characteristics to avoid abnormal current caused by a contact failure between the capacitor and the PCB.
- (5) Please refer to cautions for using on page 34 to 37 and product specifications about other notes.